

Date: Tuesday, 2/27/2007 1:00:01 PM  
 User: Eric Charbonneau

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ADAPTER
Job Number	30976		
Estimate Number	12753		
P.O. Number	N/A	Part Number	D35739
This Issue	2/27/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	U/R
Written By	<u>E</u>	Material	N/A
Checked & Approved By		Due Date	3/6/2007
Comment	Est Rev:A New Issue 07-01-29 JLM	Qty:	3
Um:	Each		

## Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X02500 	6061-T6 Bar .50" x 2.5"	
Comment: Qty.: 0.3066 f(s)/Unit Total : 0.9198 f(s) 6061-T6 Bar .50" x 2.5" Batch: M103435 <span style="float: right;">JL 07/02/28 3</span>			
2.0	BAND SAW 	BAND SAW	
Comment: BAND SAW 3.500" Cut blank 3.250" long <span style="float: right;">JL 07/02/28 3</span>			
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA679 and Dwg D3573 <span style="float: right;">J.F/M8 07/02/28</span>			
4.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">J.F/M8 07/02/28</span>			
5.0	QC8 	SECOND CHECK <b>ENGINEERING APPROVAL</b>	
Comment: SECOND CHECK <span style="float: right;">07.03.21 07.03.01</span>			
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <span style="float: right;">FJ 07/03/01</span>			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 30976

Part Number: D35739

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



M101601



(8X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f

07/03/02

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD

07/03/02

3

9.0 PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Lo D' 7/03/02 (3) Russ took

prey doobay

07/03/02

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U 07.03.05

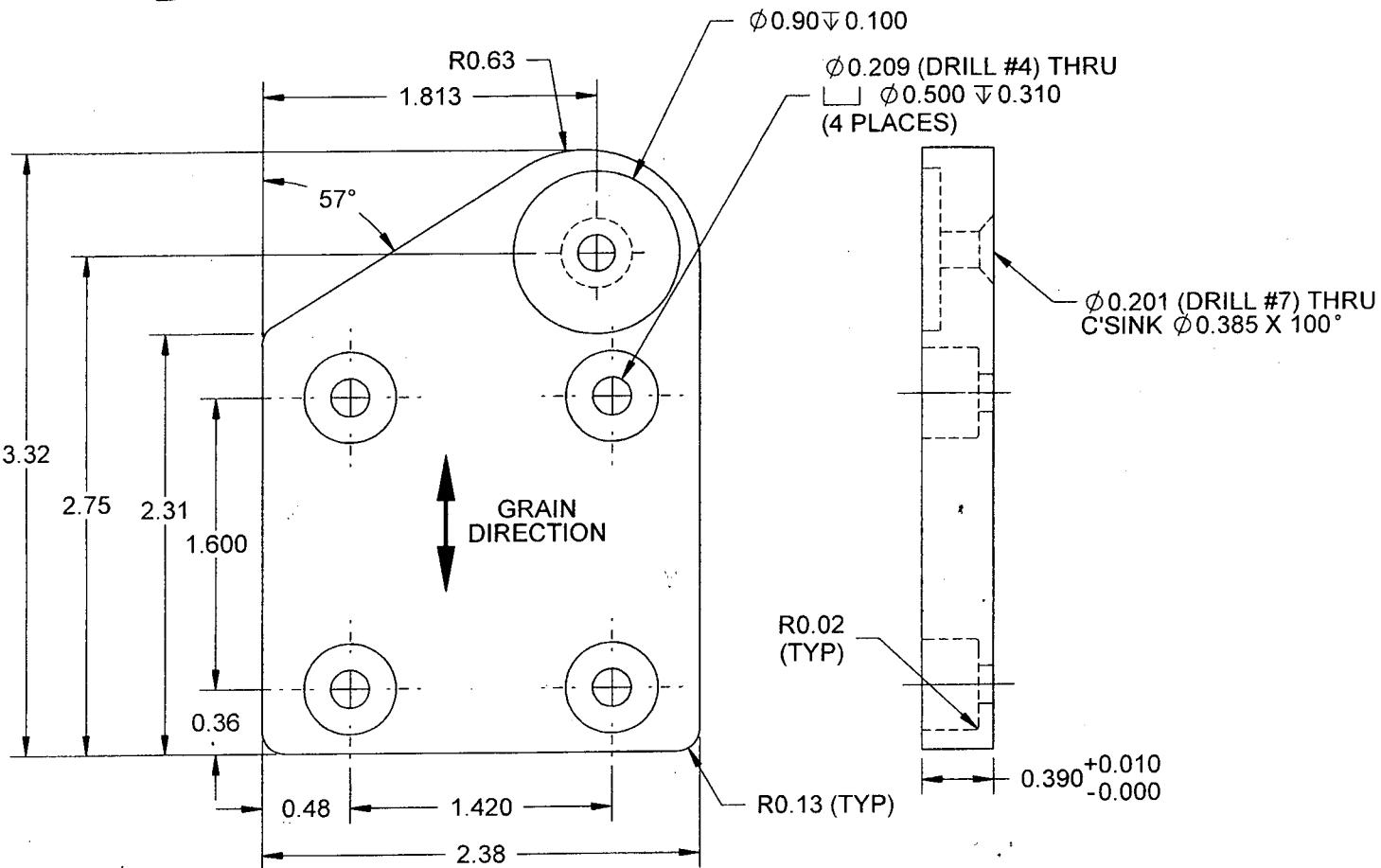
Job Completion



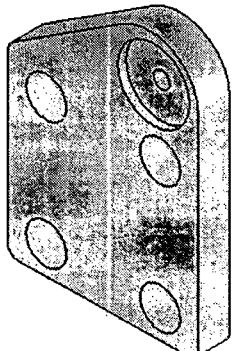
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER	SCALE 1:1	

**UNDER REVIEW**

07.02.19 *CE*



**D3573-7 ADAPTER (SHOWN)  
(D3573-9 ADAPTER (OPPOSITE)**



**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-9" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART AEROSPACE LTD

Work Order: 30976

Description: Adapter

Part Number: D3573-9

Inspection Dwg: D3573 Rev: A

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## FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Eject	Method of Inspection	Comments
R.63	$\pm .030"$	R.63"				
1.813	$\pm .010"$	1.813	✓			
57°		57°				..
3.32	$\pm .030"$	3.32	✓			
2.75	$\pm .030"$	2.75	✓			
2.31	$\pm .030"$	2.31	✓			
1.600	$\pm .010"$	1.600				
.36	$\pm .030"$	.36	✓			
.48	$\pm .030"$	.48	✓			
1.420	$\pm .010"$	1.420	✓			
2.38	$\pm .030"$	2.377	✓			
R.13	$\pm .030"$	.13	✓			
R.02	$\pm .030"$	.02	✓			
.390	$+.010$ $-.000$	,395"	✓			
Ø201	$+.005$ $-.001$	.202	✓			
Ø385X100°	$\pm .010"$		✓			
Ø.209	$+.005$ $-.001$	.210	✓			
Ø.90	$\pm .030$	.898	✓			
.100	$\pm .010$	.103	✓			
,500"	$\pm .010"$	,495"	✓			

Measured by:	M8/J.F.
Date:	07/02/20

Audited by:	UR
Date:	07/03/01

Prototype Approval:	UG
Date:	07.03.21

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	